

Date: Monday, 2/5/2007 8:08:14 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR ASSEMBLY
Job Number : 30608	
Estimate Number : 11403	
P.O. Number : <u>N/A</u>	Part Number : D3296041
This Issue : 2/5/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3296 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : SMALL /MED /FAB	Drawing Revision : A
Previous Run : 29241	Material : <u>N/A</u>
Written By : <u>SA</u>	Due Date : 2/18/2007 Qty: 4 Um: Each
Checked & Approved By : <u>SA 07.02.05</u>	
Comment : Est. C 05.10.14 Added step 14 KJ/EC	
Est Rev.D Revised Steps 06-11-20 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D32961	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Door Panel

Pick:

Qty	Part Number	Description	Batch
1	D3296-1	Door Panel	B 29245

B30617 x4

ml 07/02/19

2.0	D32963	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Door Panel

Pick:

Qty	Part Number	Description	Batch
1	D3296-3 Door Panel		B 30618 x 3

B 22748 x1

3.0	D31617	Hinge 14"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Hinge 14"

Batch: B 29245 x4

D31617-7

PTO

4.0	D31619	Hinge 17"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Hinge 17"

Batch: B 29246 x4

D31619-9

PTO

ml 07/02/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/23/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/02/19	4	Holes doesn't match one door Scrap one D3161-9 two	GS1042	Scrape two D3161-9 replace by new one 2x D30613	ml 07/02/20	07/03/02	GS1042	0702-27
07/02/20	3	Holes doesn't match on door Scrap one D3161-7	GS1042	Scrap one D3161-7 replace by new one ✓ B30612 New Drill jig made.	ml 07/02/20	07/03/12	GS1042	0702-27
				and 28 New Rivets MS 20479 AD4-4 ✓ - M18729	ml 07/02/20	07/03/12		

NOTE: Date & initial all entries

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Drawing Name: DOOR ASSEMBLY

Job Number: 30608

Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

MS20470AD44

Rivet, Universal Head



Comment: Qty.: 25.0000 Each(s)/Unit Total: 100.0000 Each(s)

Rivet, Universal Head

Batch: M18729

X100

✓

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Fabricate & assemble as per Dwg D3296.

m107/03/20

x4

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

107/03/02

(4)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005:4.3

107/03/02

07-03-07

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 07-03-09

4

10.0

D2137

Decal - No Step



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Decal - No Step

Pick:

Qty Part Number Description Batch

1 D2137 Decal B24358

FF 07-03-09

4

11.0

D2419

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Handle

Pick:

Qty Part Number Description Batch

1 D2419 Handle B28282

FF 07-03-09

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 30608

Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

D24620040

Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Seal

Pick:

Qty Part Number Description Batch

1 D2462-0040 Seal

B29456

FF 07-03-09

4

13.0

D24620053

Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Seal

Pick:

Qty Part Number Description Batch

1 D2462-0053 Seal

B29456

FF 07-03-09

4

14.0

D24620245

Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Seal

Pick:

Qty Part Number Description Batch

1 D2462-0245 Seal

B29456

FF 07-03-09

4

15.0

D27281

Dart Logo label small



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Dart Logo label small

Pick:

Qty Part Number Description Batch

1 D2728-1 Decal

B24215

FF 07-03-09

4

16.0

AN960JD6

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

1 AN960JD6 Washer

M6085

FF 07-03-09

4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/5/2007 8:08:15 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 30608

Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

MS20470AD46

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rivet, Universal Head

Pick:

Qty Part Number Description Batch
1 MS20470AD4-6 Rivet M18615

FF 07-03-09

4

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3296

FF 07-03-09 4

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/09 (4)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

[Handwritten signature] 07/03/09

21.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/13

Job Completion



07-03-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

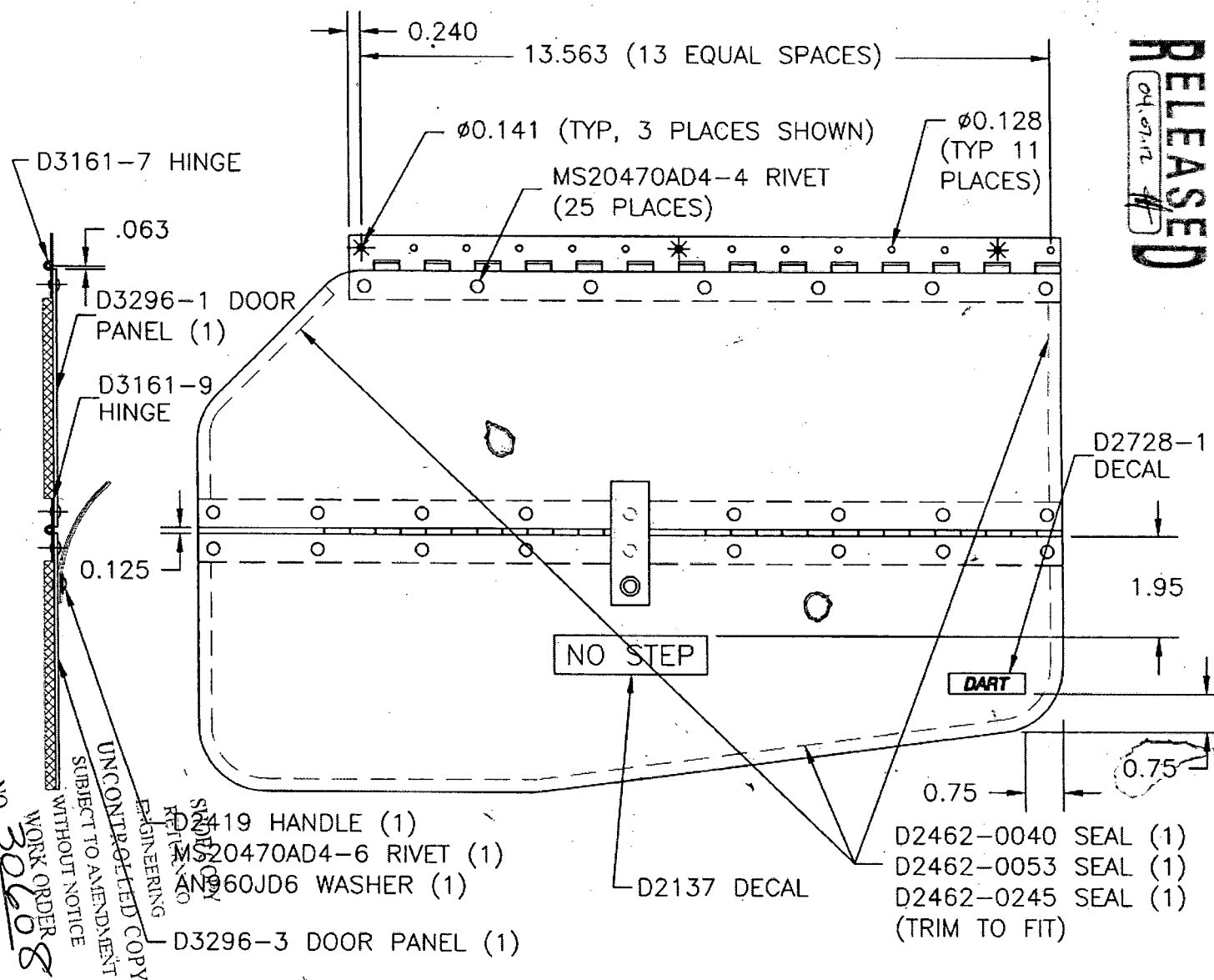
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	[Signature]	APPROVED	[Signature]	DRAWING NO.	D3296
DATE	04.06.28	TITLE	DOOR ASSEMBLY	REV. A	1 OF 2
A	04.06.28	NEW ISSUE		SCALE	1:3

RELEASED
04.07.12



D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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